

Date: Monday, 3/26/2007 3:02:25 PM
 User: Jean-Luc Menard

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LOWER STEP PROTECTIVE TRIM
Job Number : 31511	
Estimate Number : 12809	
P.O. Number : N/A	Part Number : D36083
This Issue : 3/26/2007 S.O. No. : N/A	Drawing Number : D3608 UNDER REVIEW
Prsht Rev. : NC	Project Number : AC0001
First Issue : N/A	Drawing Revision : U/R
Previous Run : N/A	Material : N/A
Written By : <u>Est Rev: A</u>	Due Date : 4/2/2007 Qty: 1 Um: Each
Checked & Approved By : <u>07-03-26</u>	
Comment : Est Rev: A New Issue 07-03-26 JLM	

Additional Product

FOR ENGINEERING USE ONLY

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S22GA 304/316 .032 Sheet



Comment: Qty.: 0.7329 sf(s)/Unit Total: 0.7329 sf(s)

304/316 .032 Sheet

Batch: m102159m1070327

①

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3608

Dwg Rev: URProg Rev: U/Rm1070327

①

2-Deburr if necessary

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE

m1070328

①

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK

07.04.03ENGINEERING
APPROVAL

Comment: SECOND CHECK

07.04.03

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Bend as per Dwg D3608

N/A

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



N/A



Comment: INSPECT WORK TO CURRENT STEP

FOR ENGINEERING USE ONLY

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

FOR ENGINEERING USE ONLY

Identify and Stock

Location: _____

07 04 03

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/04/05

U 07/04/05

Job Completion



door opener

00071

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED	DRAWING NO. D3608	REV. A SHEET 3 OF 3
DATE 07.03.15		TITLE STEP PROTECTIVE TRIM	SCALE 1:2



NOTES:

NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 24 GAUGE (0.025 THICK)
PER AMS 5513 OR AMS 5524 (REF. DART SPEC. M304S24GA)

- 2) FINISH: NONE
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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DART AEROSPACE LTD		Work Order: 31511
Description: Lower step Protective trim		Part Number: D3608-3
Inspection Dwg: D3608 Rev: 01R		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☐ First Article ☒ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	2.20	+/-0.030	2.20	✓		VERN	
B	3.35	+/-0.030	3.349	✓		VERN	
C	86°	+/- 1/2°	86°	✓		Angle Meter	
D	94°	+/- 1/2°	94°	✓		Angle Meter	
E	87°	+/- 1/2°	87°	✓		Angle Meter	
F	3.30	+/-0.030	3.30	✓		VERN	
G	0.032	+/-0.010	0.030	✓		VERN	
H							
I							
J							
K							
L							
M							
N							
O							
P							
Q							
R							
S							
T							
U							
V							
W							
X							
Y							

Measured by: <i>mm.m</i>	Audited by: <i>E</i>	Prototype Approval: <i>N/A</i>
Date: 070328	Date: 07.04.03	Date: <i>N/A 07.04.03</i>

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	